

SOLD
5021845

Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4776-1

Job Sheet 172533



Part No: D4776-1

Job Qty: 24 ea 11 ea

Part Name: Basket Strut Clevis



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/20/18

Job Tracking No:

Due Date: 3/2/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG REV D SHEET 1 IPP REV:A 13.02.28 NEW ISSUE DD VERF:JFS IPP REV:B 13.09.26 AS PER REV.B
DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	24 Ea	3/1/18	3/1/18	0.00	0.00	Start Up Machining-3		18/03/19
100	Doosan	24 pcs	3/1/18	3/1/18	0.54	12.77	Doosan		18/03/19
105	QC	24 pcs	3/1/18	3/1/18	0.00	0.00	QC2 Machining-3		18/03/19
111	QC	24 pcs	3/1/18	3/1/18	0.00	0.00	QC8 Machining-3		18/03/20
112	HandFinish	24 pcs	3/1/18	3/1/18	0.00	0.69	HandFinish1		SA 18-3-21
113	QC	24 pcs	3/1/18	3/1/18	0.00	0.00	QC7-4		18-3-21
115	Powdercoat	24 pcs	3/2/18	3/2/18	0.00	0.28	Powdercoat1		18-3-21
116	QC	24 pcs	3/2/18	3/2/18	0.00	0.00	QC3		
130	Packaging	24 pcs	3/2/18	3/2/18	0.00	0.00	Packaging3-2	8/114	
140	QC21-SA	24 Ea	3/2/18	3/2/18	0.00	0.00	QC21		MAR 21 2018

Part Op 100 - 1 - Turn as per Folio FB167 Dwg D4776 Rev: 2

Descriptions: 115 - MASK .403 ROUND SECTION AS PER DWG

M 138760 START: 11:45 ON T: 320° FINISH: 12:15

Job BOM

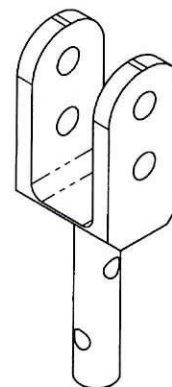
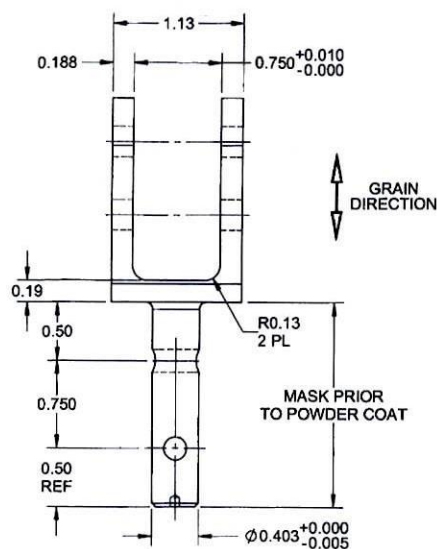
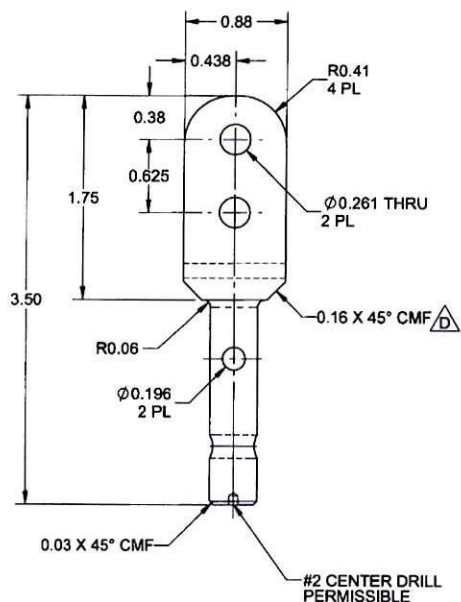
Part / Item	Component Name	Quantity	Operation	Container
M6061T6R1.500	6061-T6 Round Bar 1.50	6.9600 ft (.29 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6R1.500	7	10	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Basket Strut Clevis	0.880Inches ± 0.030	0.875 0.910 0.850		
2	Basket Strut Clevis	0.438Inches ± 0.010	0.433 0.448 0.428		
3	Basket Strut Clevis	0.380Inches ± 0.030	0.379 0.410 0.350		
4	Basket Strut Clevis	0.625Inches ± 0.010	0.625 0.635 0.615		
5	Basket Strut Clevis	1.750Inches ± 0.030	1.750 1.780 1.720		
6	Basket Strut Clevis	3.500Inches ± 0.030	3.502 3.530 3.470		
7	Basket Strut Clevis	45.000Degrees ± 0.500	45° 45.500 44.500	Angle	
8	Basket Strut Clevis	0.030Inches ± 0.030	0.030 0.060 0.000		
9	Basket Strut Clevis	0.060Inches ± 0.030	0.060 0.090 0.030	Radius	
10	Basket Strut Clevis	0.196Inches + 0.006 - 0.001	0.198 0.202 0.195	Diameter	
11	Basket Strut Clevis	0.261Inches + 0.006 - 0.001	0.262 0.267 0.260	Diameter	
12	Basket Strut Clevis	0.410Inches ± 0.030	0.410 0.440 0.380	Radius	
13	Basket Strut Clevis	1.130Inches ± 0.030	1.125 1.160 1.100		
14	Basket Strut Clevis	0.188Inches ± 0.010	0.184 0.198 0.178		
15	Basket Strut Clevis	0.190Inches ± 0.030	0.191 0.220 0.160		
16	Basket Strut Clevis	0.500Inches ± 0.030	0.500 0.530 0.470		
17	Basket Strut Clevis	0.750Inches ± 0.010	0.750 0.760 0.740		
18	Basket Strut Clevis	0.403Inches + 0.000 - 0.005	0.400 0.403 0.398	Diameter	
19	Basket Strut Clevis	0.130Inches ± 0.030	0.130 0.160 0.100	Radius	
20	Basket Strut Clevis	0.750Inches + 0.010 - 0.000	0.755 0.760 0.750		
21	Basket Strut Clevis	0.160Inches ± 0.030	0.160 0.190 0.130		
22	Basket Strut Clevis	45.000Degrees ± 0.500	45° 45.500 44.500	Angle	

Plex 2/20/18 11:14 AM dart.logan.david



D4776-1 BASKET STRUT CLEVIS

RELEASED
2014-07-30

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8
(OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4180)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs

20180220

NO. 172533

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

D	SHT 1, C6 CHAMFER ADDED. SEE PAR 14-353. SHT 2, ZONE B2 1.813 DIM ADDED FOR CLARITY. ZONE B3 0.53 DIM CORRECTED TO 0.55 DUE TO DESIGN ERROR SEE PAR 14-328.	AJS	14.07.14
C	SHT 2, C7, 1.13 DIM WAS 0.88, C8 0.688 WAS 0.438. ADDED TOP VIEW WITH CHAMFERS. REASON: INTERFERENCE WITH OEM SADDLES.	AJS	13.10.31
B	MULTIPLE DIMENSIONS UPDATED ON -1 FOR INSTALLATION OF 1/4" FASTENERS. INDEX OF HOLES ON THE STEM OF -1 ROTATED 90°. FINISH ADDED TO -1. TOLERANCE ON CLEVIS FOR -1 & -3 TIGHTENED. ADDED -5. REASON: EASE OF INSTALLATION. C3-2 DEPTH DIM ADDED.	AJS	13.08.14
A	NEW ISSUE	AJS	13.08.08
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4776 BASKET STRUT MACHINED PARTS COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN	AJS		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	14.07.14		
		REV. D	SHEET 1 OF 3
		TITLE	SCALE
		NTS	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :		Step #:		QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation				Disposition			
				Completed By			
				Lead hand / Supervisor Approval Verification			
				QC / QA Coordinator Approval			

FAULT CATEGORY

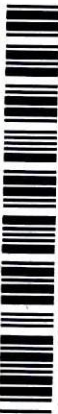
Defect Complete/Unqualified	☐ Power Loss/Surge	☐ Positioned Wrong
	☐ Folio/Program	☐ Outside Dimensions
	☐ Grain	☐ Over/Under tolerance
	☐ Weld	☐ Part Incorrect
Complete/Unclear	☐ Wrong Stock Pulled	☐ Part Lost/Missing
	☐ Out of Sequence	☐ Part Moved
	☐ Off-set	☐ Drawing
	☐ Mislabeled	☐ Finish
	☐ Fit/Function	☐ Misread
	☐ Misaligned/off center	☐ Turning Sequence

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Date: 03/19/18



Container No: S052574



Part: D4776-1

Job No: 172533

Serial No/Batch: S052574

Revision:
Inspector: